

Work Order ID 116696

Wednesday, April 23, 2014 12:44:23 PM

116696

Page 1

Item ID: D5023-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Instrument Panel Assembly
 Start Date: 4/23/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/30/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: mf. Date: 14-4-23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5023	AUR <u>prelim</u> <u>Pow B.</u>								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	1- ASSEMBLE AS PER DWG 2- GLUE RUBBER PAD AS PER DWG A/R Contact Cement Batch: <u>M128871</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

PRELIMINARY ISSUE
 Run Start ***NR1***
 Stop ***NR2***

DAS
36
9-89

DAS
27
9-89

14/4/30

14/04/30

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 116696

Wednesday, April 23, 2014 12:44:23 PM

116696

Page 2

Item ID: D5023-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Instrument Panel Assembly

Stop *NS2*

Start Date: 4/23/2014 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 4/30/2014 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00							DAS 9 9-89
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE DAS AUTH _____

RELEASED 9 DATE 12-24-04

Q Rev B

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

Work Order ID: 116696

116696

Parent Item: D5023-041

D5023-041

Parent Item Name: Instrument Panel Assembly

Start Date: 4/23/2014

Required Date: 4/30/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.12.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5023-043 *D5023-043* Instrument Panel Shell Assembly		Manufactured	No				Each	0.0000		1		14/04/30	DAS 36 9-89
D5023-3 *D5023-3* Cover Plate		Manufactured	No				Each	5.0000		1		DAS 32 9-89	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		5							
					111121	5				111121			DAS 36 9-89
D5024-041 *D5024-041* Instrument Panel Cap Assembly		Manufactured	No				Each	2.0000		1		14/04/30	DAS 36 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST191		2							
					112899	2							DAS 36 9-89
D5025-1 *D5025-1* Base Mounting Bracket		Manufactured	No				Each	0.0000		1		14/04/30	DAS 36 9-89
D5026-1 *D5026-1* Upper Support Bracket		Manufactured	No				Each	0.0000		1		14/04/30	DAS 36 9-89
D5042-1 *D5042-1* Rubber Pad		Manufactured	No				Each	0.0000		1		116701	DAS 32 9-89

B112897 (1X) **

**

**

B116629 **

B116700 **

**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Wednesday, April 23, 2014 12:44:22 PM

Page 2

Work Order ID: 116696

Parent Item: D5023-041

Parent Item Name: Instrument Panel Assembly

116696

D5023-041

Start Date: 4/23/2014

Required Date: 4/30/2014

Start Qty: 1.00

Required Qty: 1.00

AN526C1032R6

Purchased

No

Each

461.0000

28

~~*AN526C1032R6*~~

**

9216

DAS

32

Screw

9-89

AN526C1032R8

Location

Loc Qty

Loc Code

ST346

461

1892

461

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

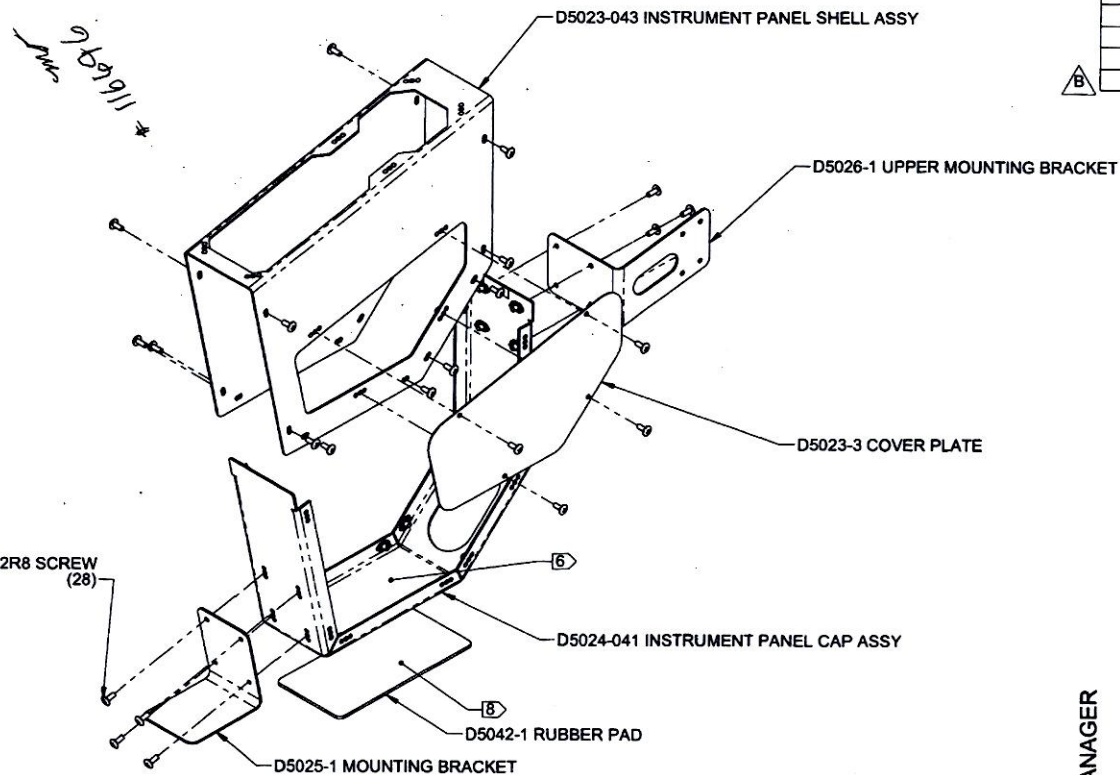
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Training									
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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D5023-041	INSTRUMENT PANEL ASSEMBLY
1	1	D5023-043	INSTRUMENT PANEL SHELL ASSY
2	1	D5023-3	COVER PLATE
3	1	D5024-041	INSTRUMENT PANEL CAP ASSEMBLY
4	1	D5025-1	MOUNTING BRACKET
5	1	D5026-1	UPPER MOUNTING BRACKET
6	1	D5042-1	RUBBER PAD
7	28	AN526C1032R8	SCREW



D5023-041 INSTRUMENT PANEL ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5023-041" PER QSI 044 6.1
- 7) WEIGHT: D5023-041: 3.99 lbs
- 8) ALIGN D5042-1 RUBBER PAD WITH BOTTOM PANEL OF D5024-041 INSTRUMENT PANEL CAP ASSY. APPLY A UNIFORM LAYER OF CONTACT CEMENT (3M 1300/1301 SCOTCHGRIP ADHESIVE OR EQUIVALENT) TO THE BACK OF THE RUBBER PAD. FIRMLY PRESS INTO POSITION.

PRELIMINARY ISSUE

DB 14.04.01

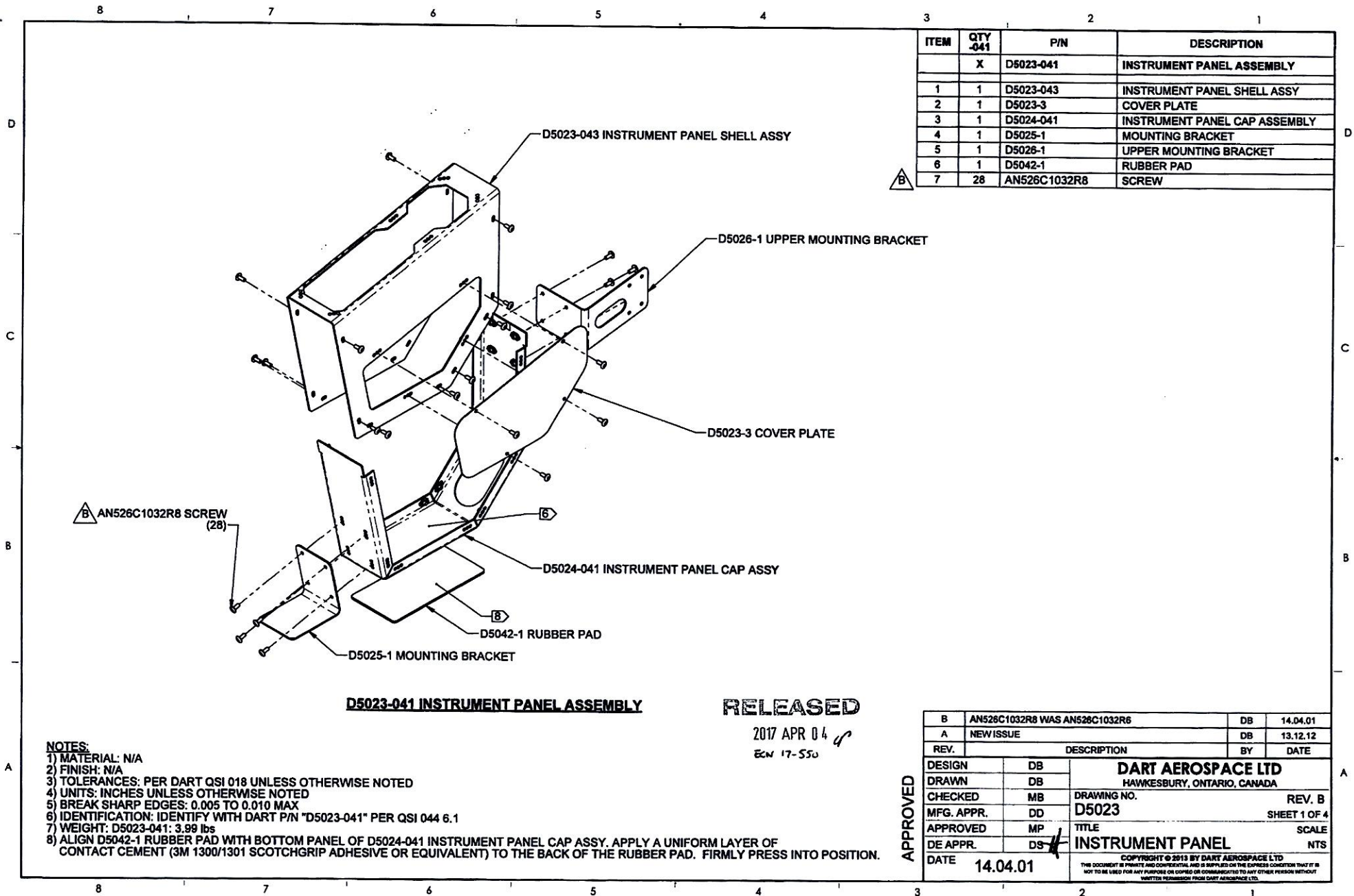
B	AN526C1032R8 WAS AN526C1032R6	DB	14.04.01
A	NEW ISSUE	DB	13.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	MB		
MFG. APPR.	DD		
APPROVED	MP		
DE APPR.	DS		
DATE	14.04.01		

APPROVED BY DESIGN MANAGER

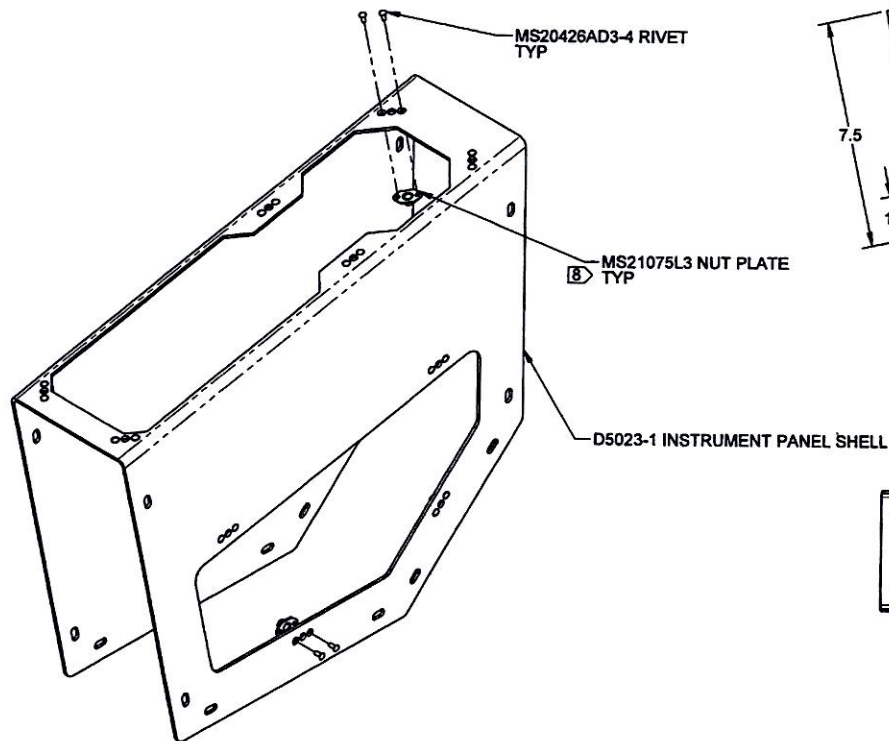
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5023** REV. B
SHEET 1 OF 4
TITLE **INSTRUMENT PANEL** SCALE NTS

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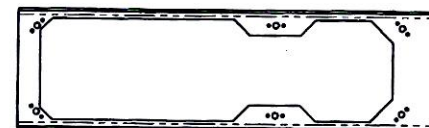
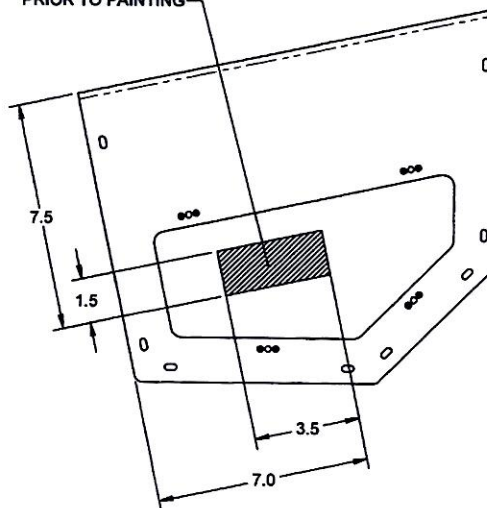


ITEM	QTY -043	P/N	DESCRIPTION
	X	D5023-043	INSTRUMENT PANEL SHELL ASSEMBLY
1	1	D5023-1	INSTRUMENT PANEL SHELL
2	10	MS21075L3	NUT PLATE, SELF-LOCKING, FLOATING
3	20	MS20426AD3-4	RIVET, CSK

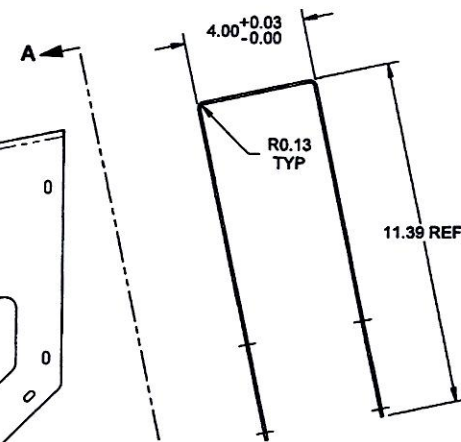


D5023-043 INSTRUMENT PANEL SHELL ASSY

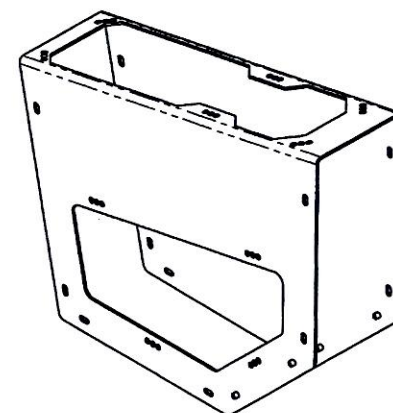
MASK THIS AREA
PRIOR TO PAINTING



D5023-1 INSTRUMENT PANEL SHELL
(MAKE FROM D5023-1F)



VIEW A-A C2-2



NOTES:

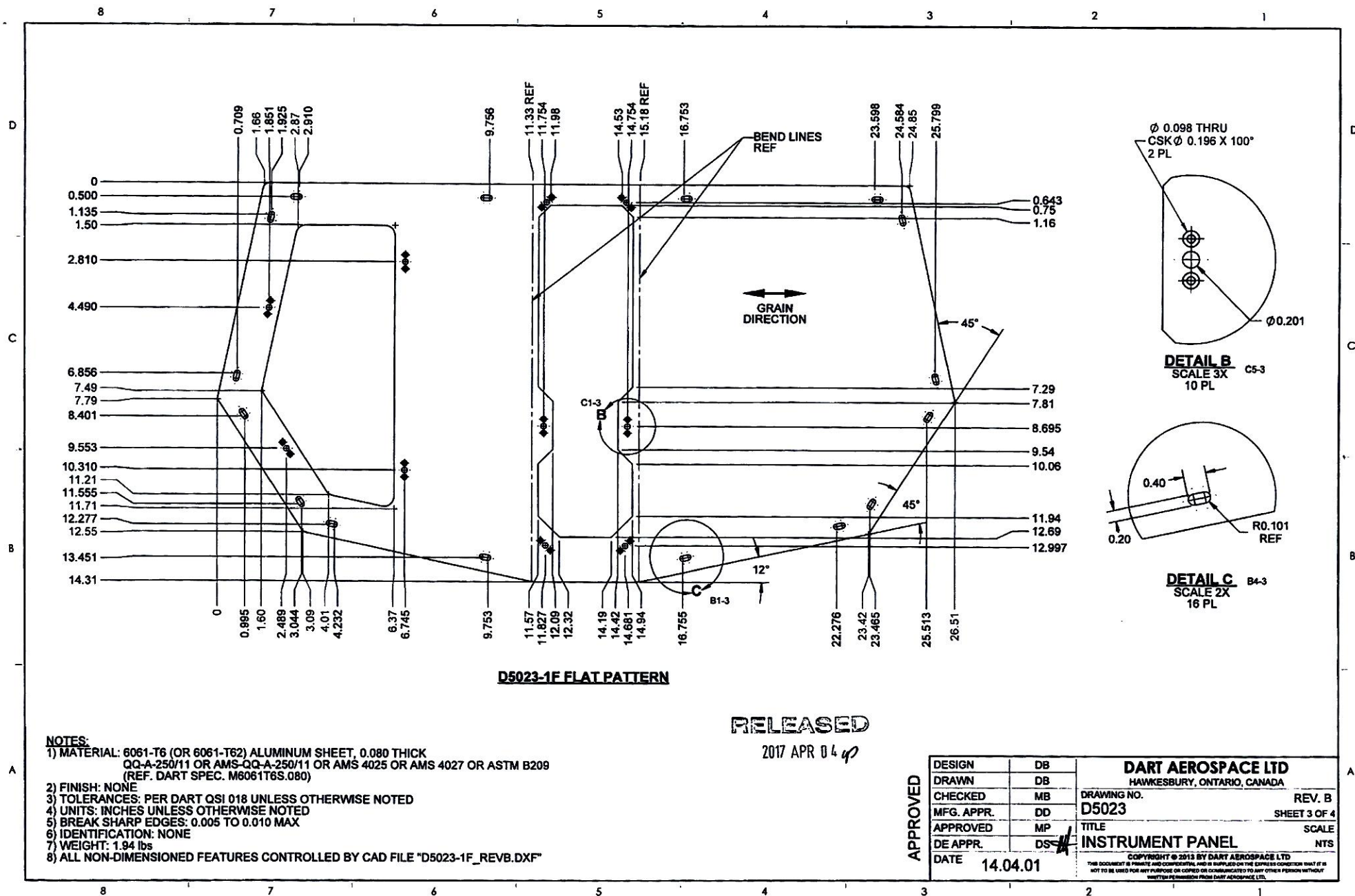
- 1) MATERIAL: N/A
- 2) FINISH: D5023-1: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
D5023-043: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D5023-043: 3.97 lbs
- 8) MASK NUTPLATE THREADS PRIOR TO PAINTING

RELEASED

2017 APR 04

APPROVED

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5023	SHEET 2 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	INSTRUMENT PANEL	NTS
DATE	14.04.01	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.94 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5023-1F_REV.B.DXF"

RELEASED

2017 APR 04

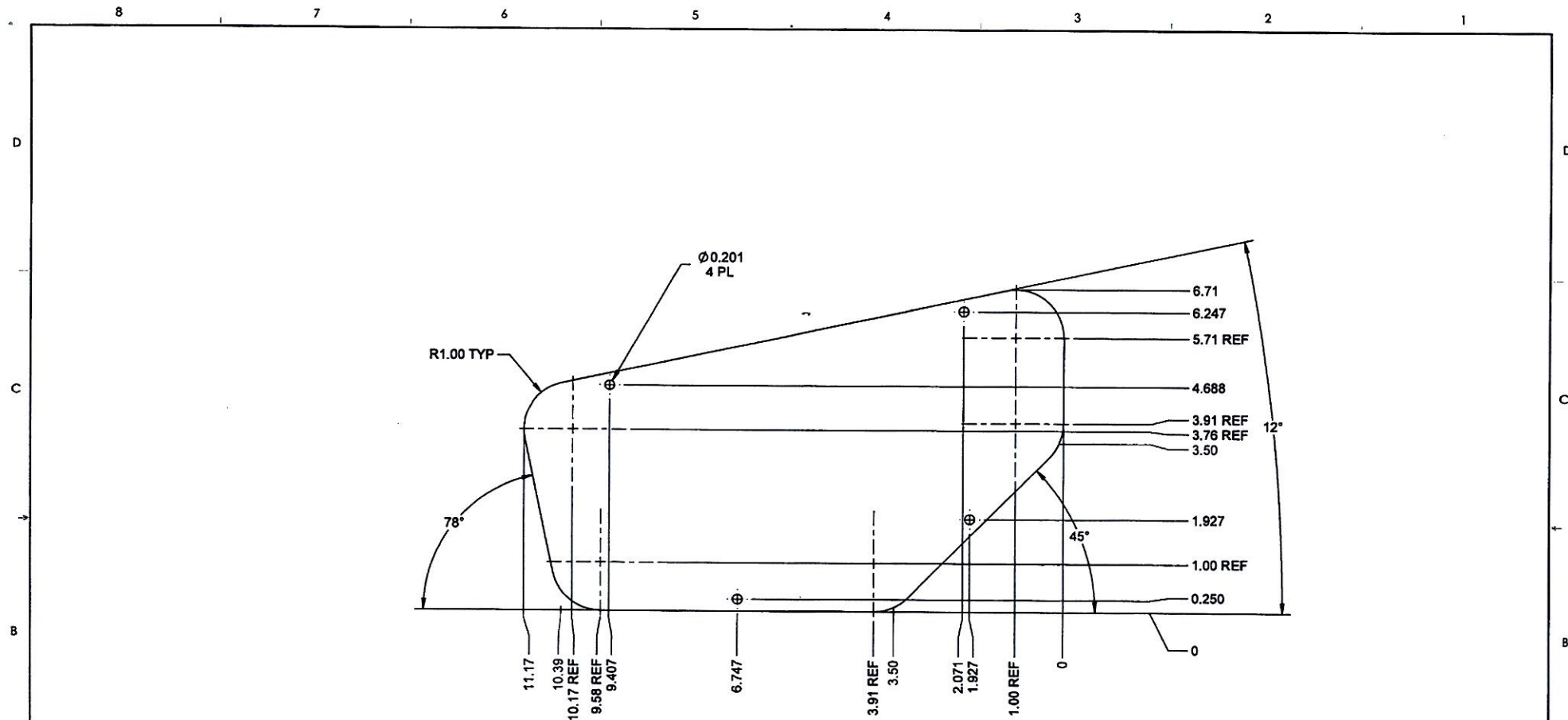
APPROVED

DESIGN	DB
DRAWN	DB
CHECKED	MB
MFG. APPR.	DD
APPROVED	MP
DE APPR.	DS
DATE	14.04.01

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5023** REV. B
SHEET 3 OF 4
TITLE **INSTRUMENT PANEL** SCALE NTS

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D5023-3 COVER PLATE

RELEASED

2017 APR 04

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK
QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.22 lbs
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D5023-3_REVB.DXF".

APPROVED

DESIGN	DB
DRAWN	DB
CHECKED	MB
MFG. APPR.	DD
APPROVED	MP
DE APPR.	DS
DATE	14.04.01

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D5023	REV. B
TITLE INSTRUMENT PANEL	SHEET 4 OF 4
SCALE NTS	
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